

Work Order ID 105873

August-23-13 8:26:17 AM

105873

A06

Page 1

Item ID: D4410-5 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Face Plate
 Start Date: 8/23/13 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 9/06/13 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: MCS Date: 13-08-23 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D4410	REV <u>PC2</u> <u>13-08-23</u>	0.00				<u>5</u>	<u>0</u>		<u>Jm 13-08-23</u>

100

Waterjet
FLOW CNC Waterjet

Memo
CUT AS PER DWG
DWG REV: B
PROG REV: B

DEBURR

SCRAP

110

QC2- Inspect parts off machine FAI/FAIB

110

QC
Quality Control

Memo

0.00

5 0 Jm 13-08-23

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
☐ Bending	☐ Bend	☐ Grain
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear
☐ Cuffs	☐ Contamination	☐ Maintenance
☐ Heat Treat	☐ Countersink	☐ Mislabelled
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread
☐ Ripples in Bend	☐ Drill Holes	☐ Offset
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration
☐ Turning Sequence	☐ Finish	☐ Out of Sequence
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions
		☐ Ovalized
		☐ Over/Under tolerance
		☐ Part Incorrect
		☐ Part Lost/Missing
		☐ Part Moved
		☐ Positioned Wrong
		☐ Power Loss/Surge
		☐ Pressure/Forced
		☐ Temperature/Cure
		☐ Weld
		☐ Wrong Stock Pulled
		☐ Other

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: ft Date: 15/05/05QA Closed: RA Date: 15/05/05

Work Order: <u>105873</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Work Order Update ☐	AGAINST DEPARTMENT/PROCESS			
Part No. <u>D4410-5</u>		Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐	Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐	Engineering ☒ Quality ☐ Other ☐
NCR No. <u>15-4883</u>					

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☒	14-12-15	130	⑤	scrap & destroy parts Re. New rev.	8 15/01/12 012047	Old Rev not taken out of stores	EB 14-12-15	14-12-15	DAS 9 9-8% 14-12-15
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General	
☐ Bending	☐ Bend	☐ Grain
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete
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☐ Turning Sequence	☐ Finish	☐ Out of Sequence
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions
		☐ Ovalized ☐ Over/Under tolerance ☒ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

105873

August-23-13 8:26:17 AM

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

5

Cust Item ID:

Start Date: 8/23/13 **Start Qty:** 5.00

5

Customer:

Required Date: 9/06/13 Req'd Qty: 5.00

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

Tool ID

Tool #	Plan Code
--------	-----------

**Accept
Qty**

Reject
Qty

Reject Number

**Insp.
Stamp**

190

QC5- Inspect part completeness to step on W/O

0.00

190

0.00

QC

Memo

Quality Control

220

Identify as per dwg & Stock Location: _____

0.00

220

Packaging

0.00

Packaging

Memo

Packaging

230

QC21- Final Inspection - Work Order Release

0.00

230

OC

Memo

Quality Control

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric to O/S ☐ Cracks ☐ Crushed/Crimped ☐ Cuffs ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Ripples in Bend ☐ Torque Waves in Extrusion ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damaged ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drill Holes ☐ Drawing ☐ Finish ☐ Folio	☐ Grain ☐ Hardware ☐ Inspection Incomplete ☐ Instructions Incomplete/Unclear ☐ Maintenance ☐ Mislabeled ☐ Misread ☐ Offset ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions
		☐ Ovalized ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Picklist Print

Page 1

August-23-13 8:26:21 AM

Work Order ID: 105873

105873

Parent Item: D4410-5

D4410-5

Parent Item Name: Face Plate

Start Date: 8/23/13

Required Date: 9/06/13

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A NEW ISSUE 11-11-02 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040		Purchased		No			sf	278.9170		0.473684			
M6061T6S 040									**	<u>0.5</u>		<u>Jun 30 - 23</u>	
6061-T6 .040 Sheet													
					<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>					
					MAT021		278.917						
					m126350		278.917						
										<u>126350</u>			

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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Unapproved									

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		☐ Wrong Stock Pulled
		☐ Other

DART AEROSPACE LTD		Work Order: 105873
Description: FACE PLATE		Part Number: 04410-5
Inspection Dwg: 04410 Rev: PC2 JP		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 0.136"	+0.005 -0.001	0.136"	-		✓	Jkm
Ø 0.150"	+0.005 -0.001	0.150"	-		✓	
Ø 0.46"	+/-0.030"	0.457"	-		✓	
Ø 0.62"	+/-0.030"	0.617"	-		✓	
0.36"	+/-0.030"	0.364"	-		✓	
3.283"	+/-0.010"	3.286"	-		✓	
0.885"	"	0.888"	-		✓	
1.150"	"	1.154"	-		✓	
4.00"	+/-0.030"	4.000"	-		✓	
0.36"	"	0.358"	-		✓	
2.283"	+/-0.010"	2.285"	-		✓	
3.00"	+/-0.030"	3.006"	-		✓	
0.920"	+/-0.010"	0.914"	-		✓	
1.185"	"	1.185"	-		✓	
1.295"	"	1.297"	-		✓	
1.94"	+/-0.030"	1.945"	-		✓	
0.760"	+/-0.010"	0.765"	-		✓	
1.198"	"	1.199"	-		✓	
1.960"	"	1.964"	-		✓	
2.335"	"	2.338"	-		✓	
0.040"	"	0.038"	-		✓	

Measured by: Jm	Audited by:	Preliminary Approval:
Date: 13-08-23	Date:	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

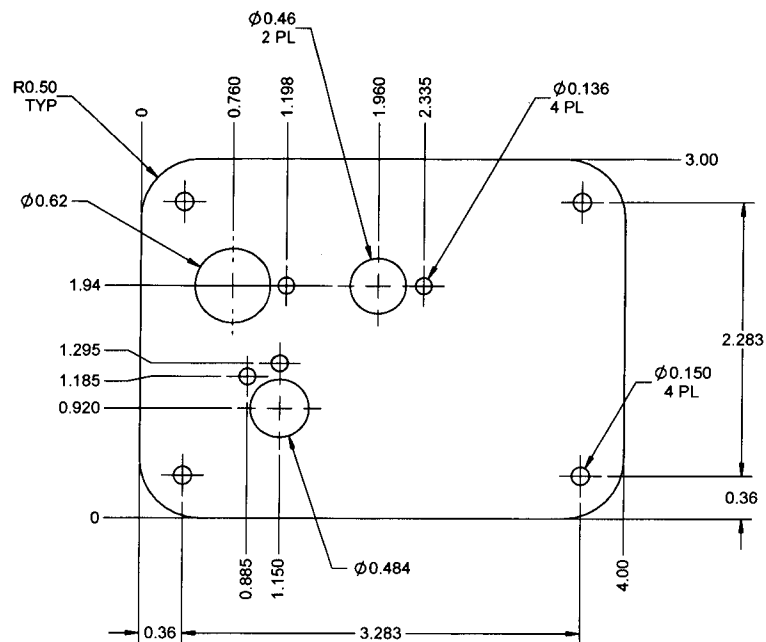
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Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric to O/S ☐ Cracks ☐ Crushed/Crimped ☐ Cuffs ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Ripples in Bend ☐ Torque Waves in Extrusion ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damaged ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drill Holes ☐ Drawing ☐ Finish ☐ Folio	☐ Grain ☐ Hardware ☐ Inspection Incomplete ☐ Instructions Incomplete/Unclear ☐ Maintenance ☐ Mislabeled ☐ Misread ☐ Offset ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions
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		☐ Pressure/Forced ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other



D4410-5 FACE PLATE

PRELIMINARY ISSUE

13.07.11

NOTES:

1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.040 THK
 QQ-A-250/11 OR AMS-QQ-A-250/11
 OR AMS 4025 OR AMS 4027
 OR ASTM B209
 REF. DART SPEC. M6061T6S.040

2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1

7) WEIGHT: 0.04 lbs

DESIGN	OS	DART AEROSPACE USA, INC.	
DRAWN	OS	KENT, WA	
CHECKED	PC	DRAWING NO.	REV. PC2
MFG APPR.	21	D4410	SHEET 7 OF 14
APPROVED		TITLE	SCALE
DE APPR.		CO-PILOT COLLECTIVE HEAD	NTS
DATE	13.07.11	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE OR COMMUNICATION TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	